

Work Order ID 67389 - 1

Thursday, March 17, 2011 11:51:55 AM



Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00

Required Date: 3/25/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan: *✓*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch: _____

cut @ Metec

110



HAAS

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine per folio FA927

DWG REV: _____

FOLIO REV: _____

(Click for crack while loading into the machine.)

2- deburr rough edges

Issue PO 13674

*Metec
Machine per drawing D2230 Rev. G*

PL 11-03-17

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Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00

Required Date: 3/25/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

QC5- Inspect parts - second check

0.00

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005-4.1

0.00

Memo

0.00

24/3/21

(63)

count
(+63)

63 BL 11-3-22

Work Order ID 67389

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Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

63X m-l 11/03/22

160

White Gloss(Ref:4 3 5.1) per QSI005 4 3-Alum

0.00



Powdercoat

M 115951.

Memo

0.00

Powder Coating

START TIME: 4:00

OVEN TEMPERATURE: 320

FINISH TIME: 4:30

63X m-l 11/03/22

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

63 BR 11-3-22

Work Order ID 67389

Thursday, March 17, 2011 11:51:55 AM



Page 4

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

G-A
w/o 66946

0.00

Packaging

ES 11/03/23 (63)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

MF
11-03-23

Picklist Print

Thursday, March 17, 2011 11:51:52 AM

Page 1

Work Order ID: 67389

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 3/17/2011

Required Date: 3/25/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	477 0414	0 0683	7.189474			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



Location

Loc Qty

Loc Code

MAT006

477.0414265

43722

180

45800

16 1914265

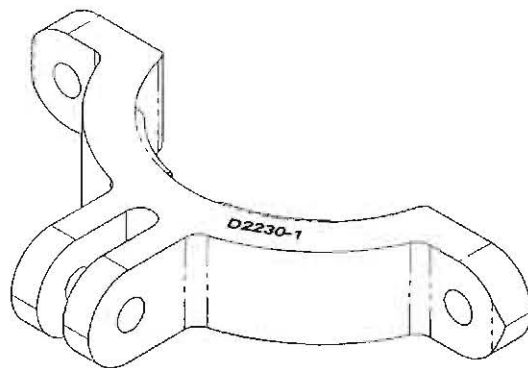
63005

280.85

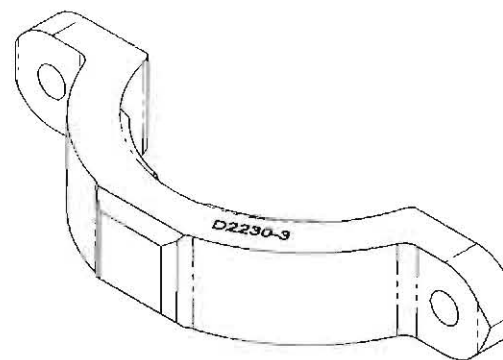
11-03-17

D2230-1 P

4/3/21 (63)



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

W/C 67384

RELEASED
01/06/15 M



NOTES

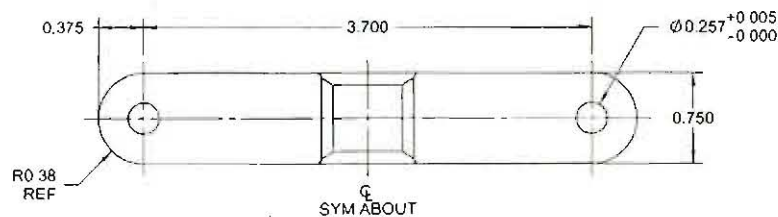
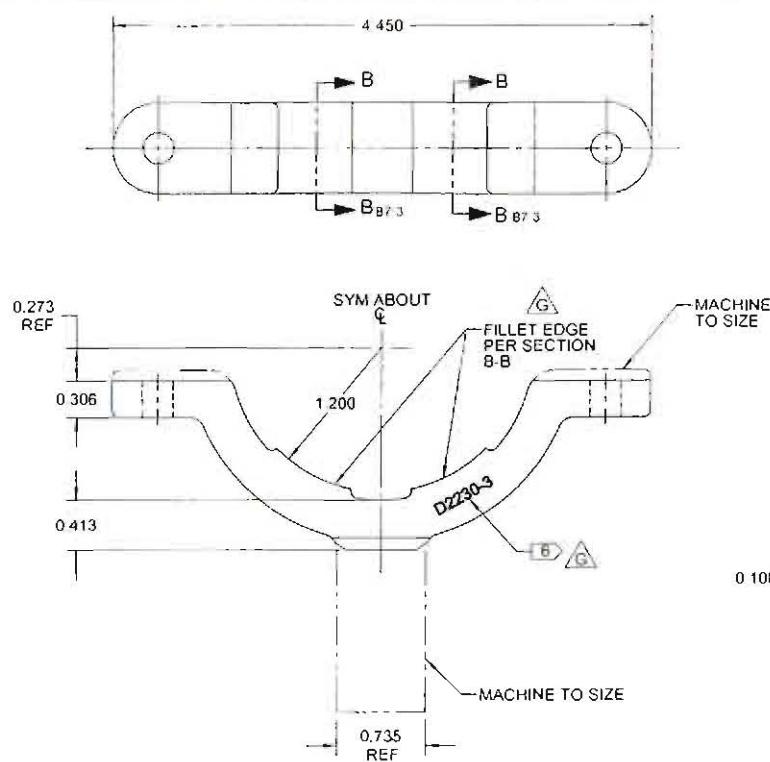
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1 0.16 lbs
-3 0.14 lbs

DESIGN	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN, R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	04.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D2230 REV G MOUNTING LUG SCALE NTS	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG APPR	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR	<i>[Signature]</i>		
DATE	09.01.16	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV G
MFG APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NIS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13674

Purchase Order Date 3/17/2011

PO Print Date 3/17/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Brigrine Golden
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	3/28/2011 Yes	100.00 Each	Yours ppd	\$19.9500	\$1,995.00

Special Inst: MACHINE PER DRWG D2230/REV:G
BATCH#67389

PO Total: \$1,995.00



Change Nbr: 1

Change Date: 3/17/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17835

Date: Mar 21, 2011

Page 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13674	Sold By: Walz, Christian D
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	63	37
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

63

D2230-1P

Mounting Lug

13674

MATERIAL: supplied by DART D2423 B63005

8/10/12

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, March 21, 2011